



Dart Aerospace Ltd.
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Canada

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D3138-1

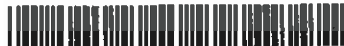
Job Sheet 199559



Part No: D3138-1

Job Qty: 2 pcs

Part Name: Cover Assembly



Small Qty - Spaced out.

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/28/19

Job Tracking No:

Due Date: 9/13/19

Created By: Jennifer Renwick

Type: SOLD

Description: Order # 13294

Note: DWG REV C IPP Rev: B 04.11.29 Made by Laser Cut KJ/RF IPP Rev: C IPP rev:D 08-05-12 now made on water jet DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	2 pcs		9/13/19	0.17	0.79	Waterjet - Flow	9/28/19	JRB
110	QC 2	2 pcs		9/13/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		

Dart Aerospace Ltd.
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CANADA
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Container No: S218073



Part: D3138-1

Job No: 199559

Serial No/Batch: S218073

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/28/19

Plex 8/28/19 1:37 PM Dart.Renwick.Jennifer

120 QC 8	2 pcs	9/13/19	0.00 0.00	QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	9/28/19 308
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	DAS SEP 30 2019 40
				QC 8 - 52	9-89
				QC 8 - 23	
				QC 8 - 57	
130 Small Fab - 2 - B4B	2 pcs	9/13/19	0.00 0.50	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	DAS
				Small Fab - 3 - B4B	30 OCT 30 2019
				Small Fab - 4 - B4B	9-89
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
140 QC 5	2 pcs	9/13/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	

						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	OCT 31 2019 40
						QC 5 - 61	9-85
						QC 5 - 81	
150 Handfinish - 1-1 Chemical- B4B	2 pcs	9/13/19	0.00	0.29		Handfinish - 1 - 1 - B4B	
						Handfinish - 1 - 2 - B4B	
						Handfinish - 1 - 3 - B4B	NOV 01 2019
						Handfinish - 1 - 4 - B4B	
						Handfinish - 1 - 5 - B4B	
						Handfinish - 1 - 6 - B4B	
						Handfinish - 1 - 7 - B4B	
						Handfinish - 1 - 8 - B4B	
						Handfinish - 1 - 9 - B4B	
						Handfinish - 1 - 10 - B4B	
						Handfinish - 1 - 11 - B4B	
						Handfinish - 1 - 12 - B4B	
						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
160 Powdercoat - 3 Grey Sand - B4B	2 pcs	9/13/19	0.00	0.18		Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	BL 19-11-01
						Powdercoat - 4 - B4B	
170 QC 3	2 pcs	9/13/19	0.00	0.00		QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	

				QC 3 - 36		
				QC 3 - 41		
				QC 3 - 51		
				QC 3 - 58		
				QC 3 - 59		
				QC 3 - 68		
				QC 3 - 9		
				QC 3 - 40	NOV 13 2019	
				QC 3 - 19	DA 40	
				QC 3 - 43	9:00	
				QC 3 - 24		
				QC 3 - 61		
				QC 3 - 81		
180	Packaging 3-1 - Stock - B4B	2	9/13/19	0.00 0.00	Packaging 3 - 1 - B4B	
	pcs				Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	ST4USA
					Packaging 3 - 5 - B4B	DAS 74
					Packaging 3 - 6 - B4B	NOV 14 2019
					Packaging 3 - 7 - B4B	9:00
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	DAS
					Packaging 3 - 26 - B4B	21
190	QC 21 - SA	2	9/13/19	0.00 0.00	QC 21 - SA - 21	9:00
		pcs			QC 21 - SA - 70	NOV 14 2019
					QC 21 - SA - 53	

Part Op 100 - 1-Cut as per Dwg D3138 Dwg Rev: C Prog Rev: C 2-Deburr if necessary

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Deburr Bend as per Dwg D3138

140 - QC5- Inspect part completeness to step on W/O

150 - Chemical Conversion Coat per QSI005 4.1

160 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3), START TIME: 8:10 OVEN TEMPERATURE: 320°

FINISH TIME: 5:40 M 138869

170 - QC3- Inspect Part Finish

180 - (Identify as per dwg & Stock Location: _____), Location : CA2

190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.032	2024-T3 .032 Sheet	3.7000 sf (1.85 ea)	100-Waterjet - Flow - 1	5018261

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.032	4	164	0

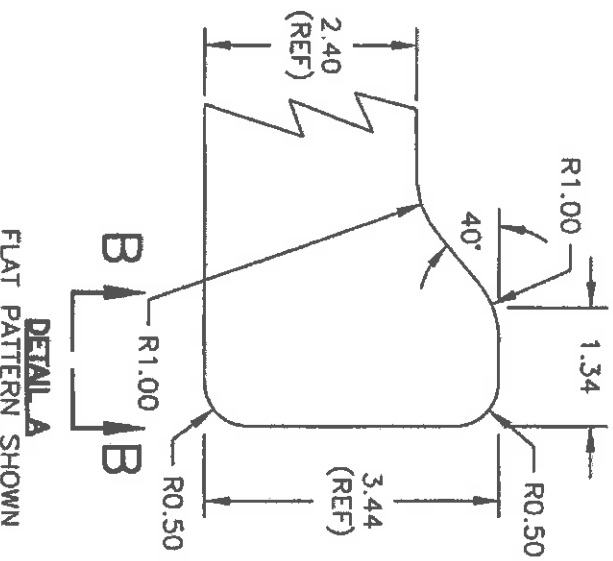
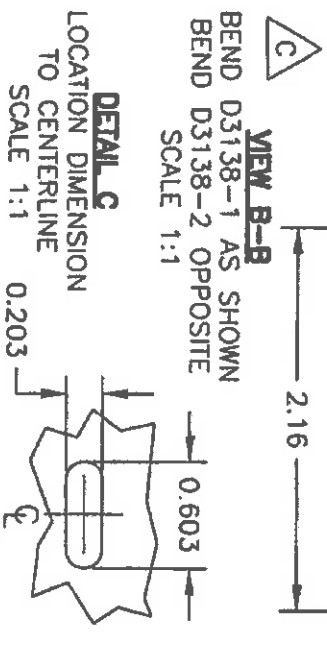
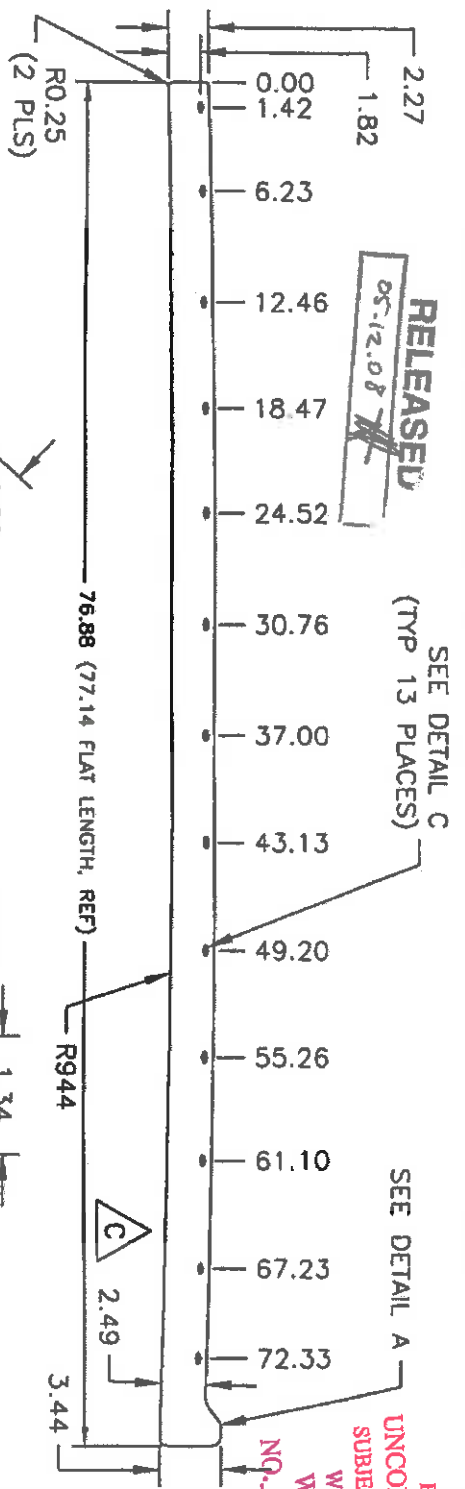
Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Cover	0.603Inches ± 0.010	0.613 0.593		
2	Cover	0.203Inches ± 0.010	0.213 0.193		
3	Cover	1.820Inches ± 0.030	1.850 1.790		
4	Cover	2.270Inches ± 0.030	2.300 2.240		
5	Cover	2.490Inches ± 0.030	2.520 2.460		
6	Cover	3.440Inches ± 0.030	3.470 3.410		
7	Cover	1.420Inches ± 0.030	1.450 1.390		
8	Cover	6.230Inches ± 0.030	6.260 6.200		
9	Cover	12.460Inches ± 0.030	12.490 12.430		
10	Cover	18.470Inches ± 0.030	18.500 18.440		
11	Cover	24.520Inches ± 0.030	24.550 24.490		
12	Cover	30.760Inches ± 0.030	30.790 30.730		
13	Cover	37.000Inches ± 0.030	37.030 36.970		
14	Cover	43.130Inches ± 0.030	43.160 43.100		
15	Cover	49.200Inches ± 0.030	49.230 49.170		
16	Cover	55.260Inches ± 0.030	55.290 55.230		
17	Cover	61.100Inches ± 0.030	61.130 61.070		
18	Cover	67.230Inches ± 0.030	67.260 67.200		
19	Cover	72.330Inches ± 0.030	72.360 72.300		
20	Cover	77.140Inches ± 0.030	77.170 77.110		

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DART

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 199559



- D3138-1 COVER (SHOWN, REPLACES PREMIER P/N B30-23000-205)**
D3138-2 COVER (BEND OPPOSITE, REPLACES PREMIER P/N B30-23000-206)
- 1) MATERIAL: 2024-T3 SHEET (00-A-250/4) 0.032 THICK (REF DART SPEC. M2024T3S.032)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
 - 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

DESIGN	CP	DRAWN BY	RF	CHECKED	APPROVED	DRAWING NO.	D3138	REV. C	SHEET 1 OF 1	SCALE	1:10
DATE	05.12.05	TITLE	COVER	NEW ISSUE	RE-DESIGN	CORRECT VIEW B-B: ADD 2.49 DIM.					
A	02 04 18										
B	04 09 20										
C	05.12.05										